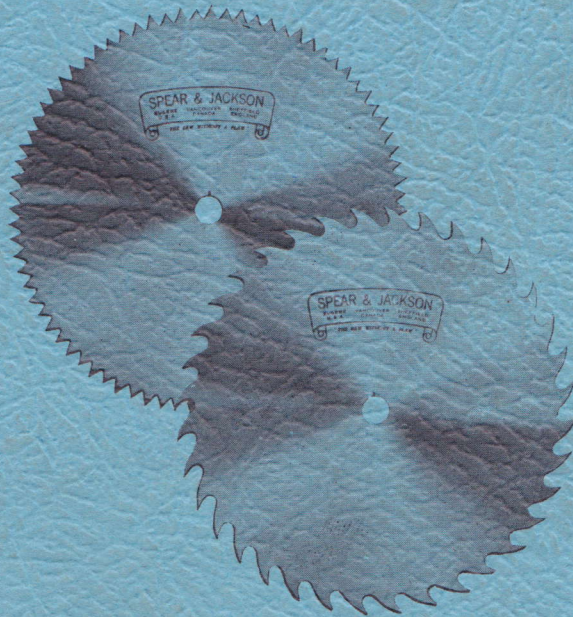
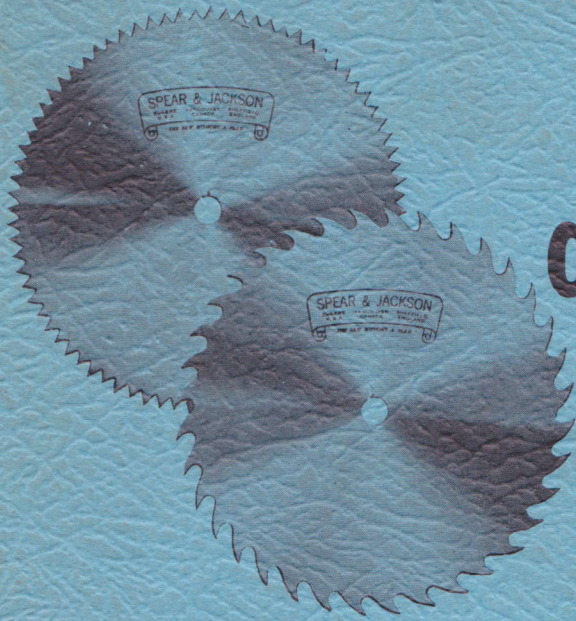


SPEAR & JACKSON

SOLID TOOTH Circular Saws

**For Every
Purpose**



"The Saw Without a Flaw"

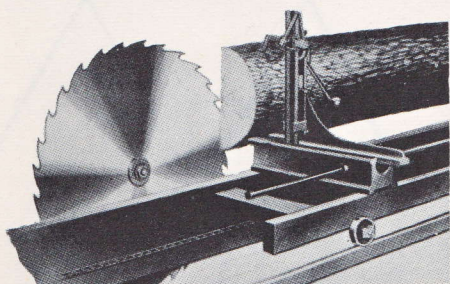
SPEAR & JACKSON (U.S.) INC.
EUGENE, OREGON

Spear & Jackson **SOLID TOOTH CIRCULAR SAWS**

Instructions for Ordering . . .

WHEN ORDERING SPEAR & JACKSON SOLID TOOTH CIRCULAR SAWS BE SURE AND SPECIFY:

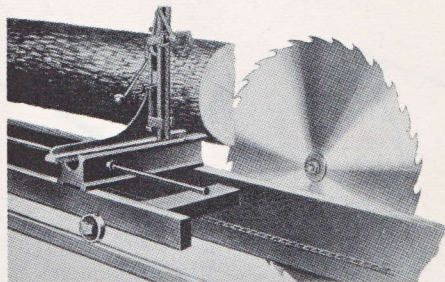
- A. Number of saws wanted.
- B. Style of saw wanted (tooth shape).
- C. Diameter of saw in inches.
- D. Right or left hand (see illustrations).
- E. Gauge (thickness) of saw at center and also at rim.
- F. Number of teeth in saw.
- G. Diameter of mandrel hole.
- H. Diameter and distance from center to center of pinholes.
- I. Number of revolutions of saw per minute while in cut.
- J. Spring or swage set.



LEFT HAND

The hand of a saw is determined by the side on which the log passes. Standing so that the saw is revolving towards you, the log passes to the right for a Right Hand Saw, and to the left for a Left Hand Saw.

How To Determine The Hand of a Saw



RIGHT HAND

"The Saw Without a Flaw"

Spear & Jackson

SOLID TOOTH CIRCULAR SAWS



Fig. 1
Standard Rip Saw



Fig. 2
Glue Joint Rip Saw



Fig. 3
Lath Saw



Fig. 4
Shingle Jointer Saw



Fig. 5
Shingle Saw



Fig. 6
Solid Tooth Log Splitting or
Head Saw



Fig. 7
Smooth Trim Saw
Hollow Ground

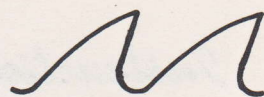


Fig. 7A
Smooth Trim Saw
Flat Ground

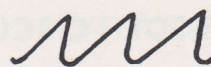


Fig. 8
Cut-Off Saw
Hook Behind Eye



Fig. 8A
Cut-Off Saw
Even Hook

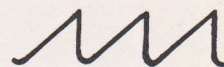


Fig. 8B
Cut-Off Saw
Hook To Eye

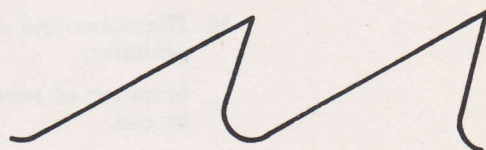


Fig. 9
Log Cut-Off Saw
Hook Behind Eye

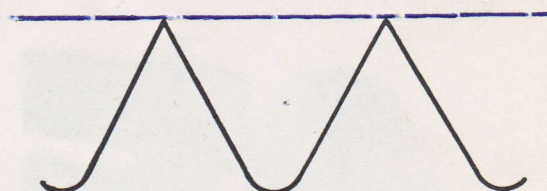


Fig. 9A
Log Cut-Off Saw
Even Hook

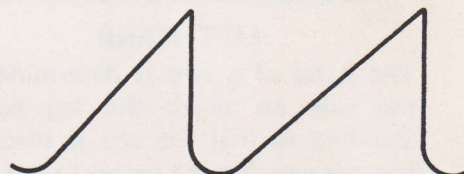
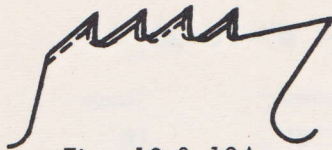


Fig. 9B
Log Cut-Off Saw
Hook to Eye

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SOLID TOOTH CIRCULAR SAWS



Figs. 10 & 10A
Combination Saw
4 Teeth & Raker

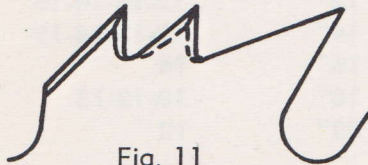


Fig. 11
Combination Saw
2 Teeth & Raker



Fig. 12
Outside Dado Saw



Fig. 13
Dado Filler



Fig. 14
Solid Tooth Groover Saw



Fig. 15
Solid Tooth Edger Saw



Fig. 16
Mitre Saw



Fig. 17
Paper Core Saw



Fig. 18
Small Lance Tooth Saw



Fig. 19
Kam Tooth Saw

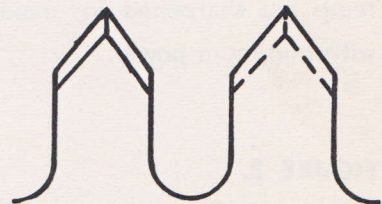


Fig. 20
Large Lance Tooth Saw

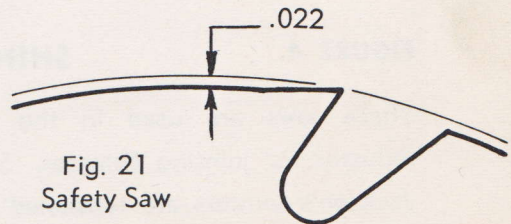


Fig. 21
Safety Saw

"The Saw Without a Flaw"

Spear & Jackson

SOLID TOOTH CIRCULAR SAWS

FIGURE 1. STANDARD RIP SAW 6" TO 20"

The specifications as shown are recommended for 6" to 20" Rip Saws on Hand Feed Machines. Two gauges heavier is recommended for Power Feed Machines. Heavier gauge saws than those listed are recommended for green lumber, or heavy cuts, and conversely a lighter gauge for lighter cuts.

Diameter	Gauge	No. of Teeth
6"	18	40
7"	18	40
8"	17-18	40
10"	14-15-16	36
12"	12-13-14-15	36
14"	12-13-14-15	36
16"	14	36
18"	10-12-13	36
20"	12	36

FIGURE 2. GLUE JOINT RIP SAW

These saws are made specially for power ripping machines where a smooth cut ready for glueing is desired. They are made of heavy gauge material and usually range from 12" to 16" in diameter. The teeth are sharpened for maximum feed with minimum power.

Diameter	Gauge	No. of Teeth
12"	12	24, 36
13"	10	24
13"	12	30
14"	10	24, 36
14"	11	30
14"	12	30, 36
16"	11	30, 36
16"	12	30, 36
18"	11	36

FIGURE 3. LATH SAW

Diameter	Gauge	No. of Teeth
12"	12	24-26-28
14"	12	24-26-30

FIGURE 4. SHINGLE JOINTER SAW

These saws are used in the shingle industry for jointing shingles. Spear & Jackson's jointers are tensioned so that their teeth will run true at cutting speed, thereby producing smooth edges without splinters.

Diameter	Gauge	No. of Teeth
36"	8-17	80
38"	8-17	80
40"	8-17	80

"The Saw Without a Flaw"

Spear & Jackson

SOLID TOOTH CIRCULAR SAWS

FIGURE 5.

SHINGLE SAW

Shingle Saws range from 36" to 50" in diameter. They are made heavy in the eye for strength and stiffness, and ground flat to a point 5 or 6 inches from the cutting edge. From this point they are tapered to 16 or 17 gauge at the rim.

Diameter	Gauge	No. of Teeth
42"	6-17	60
44"	5-16	60
46"	5-16	60
48"	5-16	60
50"	5-16	60

Shingle Saws are made Right or Left Hand. Be sure to specify which. On a left hand saw with the teeth revolving toward you the collar is on the right hand side. On a right hand saw the collar is on the left hand side.

Heading Saws are manufactured in the same manner as Shingle Saws, varying from 48" to 66" diameter, and from 14 or 15 gauge at rim with 80 or 90 teeth.

FIGURE 6.

SOLID TOOTH HEAD SAW OR LOG SAW

These large diameter solid tooth circular or head saws are used for cutting logs into lumber. They are made in diameters from 38" to 72", and from 5 to 9 gauge in thickness. Spear & Jackson's Log Saws are tempered to swage readily, yet maintain a keen cutting edge. They are precision tensioned to cut true straight lumber when in operation at speeds specified. When ordering be sure to state hand of saw.

Diameter	Gauge	No. of Teeth
46"	8-9	40
48"	7-8	40
50"	7-8	40
52"	7-8	40
54"	7-8	44
56"	6	80-90
60"	6-7	70-80-90
62"	6-7	90
64"	6-7	90
66"	5-6	90
72"	5	60

"The Saw Without a Flaw"

Spear & Jackson **SOLID TOOTH CIRCULAR SAWS**

FIGURE 7.

SMOOTH TRIM SAW — HOLLOW GROUND

This tooth shape is used extensively by mill operators for smooth precision trimming. Trade marking and grade marking lumber has necessitated the designing of this type of tooth. With Spear & Jackson's method of hollow grinding and tensioning

these saws will give long trouble-free service. They are made in a wide variety of gauges and diameters. This tooth face is bevelled at 45° to give a planing action to the wood, and is made with 7/16", 1/2", 5/8", 3/4" and 1" tooth spacing.

For Cutting Dry Lumber-Power Feed Machines

Diameter	Gauge	No. of Teeth
18"	8-12-8	150
20"	8-12-8	160
22"	7-11-7	180
24"	6-10-6	180
26"	7-11-7	160
28"	6-10-6	170
30"	5-9-5	150

For Cutting Green Lumber-Power Feed Machines

Diameter	Gauge	No. of Teeth
18"	8-13-8	90
20"	7-12-7	100
22"	6-11-6	100
24"	6-11-6	120
26"	6-11-6	130
28"	6-10-6	130
30"	5-9-5	140

FIGURE 7A.

SMOOTH TRIM SAW — FLAT GROUND

This type of tooth is used for trimming lumber to specified lengths. Trimmer machines are equipped with 2, 8, 13, 21, 31 saws. Accompanying list shows standard diameters and number of teeth. However, saws with a special number of teeth can be manufactured to customer's specifications.

Diameter	Gauge	No. of Teeth
18"	10	60-80-100
20"	10	70
22"	10	60
24"	10	70
26"	10	70
28"	9-10	70
30"	9	70
32"	8	70-100
34"	9	70
36"	8	80
38"	8	80

"The Saw Without a Flaw"

Spear & Jackson

SOLID TOOTH CIRCULAR SAWS

FIGURE 8, 8A, 8B

CUT-OFF SAW

These styles of teeth are used extensively when cutting with small diameter saws.

FIGURE 8 is recommended when cutting with the top portion of the saw.

FIGURE 8A is recommended when cutting with the work below the center of the saw.

FIGURE 8B is recommended when cutting with the work above the center of the saw.

Diameter	Gauge	No. of Teeth
6"	18	100-120
7"	18	110
8"	18	100-150
9"	16	100
10"	16	100-150
12"	14	70-100-150
14"	14	60-80-100-150
16"	14	60-80-100-150-200
18"	13	60-80-100
20"	12	80
22"	11	70
24"	10	70
26"	10	70
28"	10	70
30"	10	70
32"	9	70
34"	8	80
36"	9	70

Diameter	Gauge	No. of Teeth
38"	8	80
40"	6 & 7	80
42"	6 & 8	80
44"	6	80
46"	7	80
48"	7	90
50"	6	90
52"	7	90
54"	6	100
56"	6	100
58"	6	100
60"	6	120
62"	5	120
64"	5	120
66"	5	120
68"	5	120
70"	5	120
72"	5	120
74"	5	120
76"	5	120
78"	5	128

FIGURE 9, 9A, 9B.

CUT-OFF SAW

These figures show Cut-off Teeth for larger diameter saws. See list above for standard gauges and number of teeth. Figure 9A is used extensively for Slasher

Saws where the cutting is done on the bottom part of the saw. For various applications of these styles of teeth refer to Figure 8, 8A and 8B.

FIGURE 10.

COMBINATION SAW—4 TEETH & RAKER — HOLLOW GROUND

Designed for hand feed to rip, cut-off or mitre. The manner in which it is hollow ground for clearance and the hook of the cleaner and cutting teeth allows for a faster and freer cutting saw.

Diameter	Gauge	No. of Sections
6"	16-19-16	10
7"	14-17-14	10
8"	14-17-14	12
10"	13-16-13	16
12"	12-15-12	18
14"	11-14-11	18
16"	11-14-11	20
18"	10-13-10	22
20"	10-13-10	24
24"	9-12-9	30

"The Saw Without a Flaw"

Spear & Jackson

SOLID TOOTH CIRCULAR SAWS

FIGURE 10A.

COMBINATION OR NOVELTY SAW — 4 TEETH & RAKER FLAT GROUND

Combination or Novelty Saw is similar to Figure 10 except that it is flat ground and the teeth are set for clearance. It has four cutting teeth and one cleaner tooth per section. Recommended for trimming to length and mitre work.

Diameter	Gauge	No. of Sections
6"	17	12
8"	17	14
10"	15	16
12"	14	18
14"	13	20
16"	13	22

FIGURE 11.

FLAT GROUND COMBINATION SAW — 2 TEETH & RAKER

Flat ground Combination Saws are made with 2 cutting teeth and one cleaner tooth per section. The cutting teeth are set for clearance and are 1/64" longer than the raker or cleaner tooth. It is an extremely fast cutting saw and is used extensively for ripping and mitering.

Diameter	Gauge	No. of Sections
8"	15	16
10"	14	18
12"	13	20
14"	12	22
16"	12	24
18"	11	26
20"	10	28
22"	9	30

FIGURES 12 & 13.

DADO HEADS

A Dado Head is made up with two outside saws 1/8" thick, and with fillers can be used to cut grooves up to 4-1/16" wide. Outside saws and fillers are made

in the following diameters: 5, 6, 7, 8, 9, 10, 11, 12, 14 and 16 inches. The Dado Heads are arranged in standard sets as follows:

	Outside Saws	Fillers		
		1/16"	1/8"	1/4"
No. 1 Set cuts 1/8" to 7/16"	2	1	1	
No. 2 Set cuts 1/8" to 11/16"	2	1	1	1
No. 3 Set cuts 1/8" to 13/16"	2	1	2	1
No. 4 Set cuts 1/8" to 1-1/16"	2	1	2	2
No. 5 Set cuts 1/8" to 1-9/16"	2	1	2	4
No. 6 Set cuts 1/8" to 2-1/16"	2	1	2	6
No. 7 Set cuts 1/8" to 3-1/16"	2	1	2	10
No. 8 Set cuts 1/8" to 4-1/16"	2	1	2	14

FIGURE 14.

SOLID TOOTH GROOVING SAW

These saws are used to cut grooves with the grain only.

Diameter:	5, 6, 7, 8, 9, 10, 11, 12, 14, 16 and 18"
Thickness:	1/8, 3/16, 1/4, 5/16, 3/8, 7/16 and 1/2"

"The Saw Without a Flaw"

Spear & Jackson **SOLID TOOTH CIRCULAR SAWS**

FIGURE 15. SOLID TOOTH EDGER SAW

Edger Saws are used for trimming the edges of lumber to specified widths as the lumber leaves the log saws. Edger

machines usually are equipped with from 2 to 6 saws either swaged or spring set.

Diameter	Gauge	No. of Teeth	Diameter	Gauge	No. of Teeth
12"	8	20	20"	8	24
12"	12	24	20"	9	30
14"	9	30	22"	7	24
14"	10	30	22"	8	30
16"	9	24	24"	7	30
16"	10	30	24"	8	30
18"	7	24	26"	6	30
18"	9	30	26"	8	30
			30"	6	30

FIGURE 16. MITRE SAWS — HOLLOW GROUND

A popular tooth with Spear & Jackson users. Many manufacturers rely on this tooth for a smooth finishing cut.

Diameter	Gauge	No. of Teeth
6"	16-19-16	150
7"	16-19-16	150
8"	16-19-16	150
10"	14-17-14	150
12"	13-16-13	150
14"	12-15-12	200
16"	12-15-12	200

FIGURE 17. PAPER CORE SAW

This tooth is used in paper mills for cutting off cardboard cores. It is hollow ground to produce a clean cut free from feather edges.

Diameter	Gauge	No. of Teeth
10"	13-16-13	72
12"	13-16-13	84
14"	12-15-12	100
16"	12-15-12	116
18"	11-14-11	130
20"	11-14-11	140

FIGURES 18 & 20. LANCE TOOTH SAW

This fast cutting tooth is used on all sizes of saws. It is free cutting and easily kept to the proper shape.

Figure 18—Used on small diameter saws.

Figure 20—Used on large diameter saws, especially popular in small mills due to its easily kept shape. For standard number of teeth see Cut-off Saw list (FIG. 8).

"The Saw Without a Flaw"

Spear & Jackson **SOLID TOOTH CIRCULAR SAWS**

FIGURE 19.

KAM TOOTH SAW

This tooth is favored by many filers because of its easily kept shape. It is used from 12" to 18" for smooth trimming

and can be supplied on saws up to 56" diameter. It can be supplied either flat or hollow ground.

FIGURE 21.

SAFETY SAW

These saws are designed to cut freely with a minimum of kickback. This is accomplished by using the heel of the tooth to limit the feed to a predetermined rate.

For this reason they are used extensively in schools and home workshops. They are made in standard rip and combination sizes.

RIP SAW

Diameter	Gauge	No. of Teeth
6"	18	8
7"	16	8
8"	16	8
9"	16	8
10"	16	8
12"	14	8
14"	12	8
16"	12	8

COMBINATION SAW

Diameter	Gauge	No. of Teeth
8"	16	12
9"	16	12
10"	16	12
12"	14	12
14"	12	12
16"	12	12

"The Saw Without a Flaw"

Spear & Jackson **FILING ROOM TOOLS**

SAW MAKERS' STRAIGHT EDGES



Furnished in the following lengths:

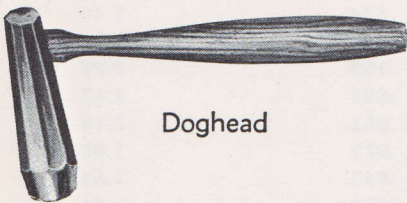
6", 9", 13", 15", 24", 36", 48", 60"



Twist-Face



Cross-Face



Doghead

SAW MAKERS' HAMMERS

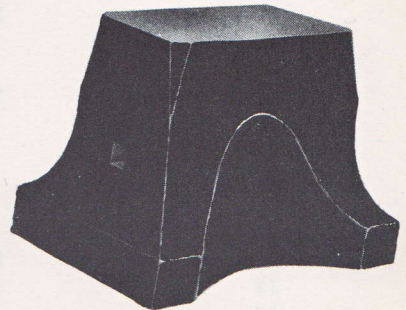
Forged from best tool steel; truly balanced with highly polished faces to prevent marking or cutting finished saws. With best hickory handles. Twist Face, Cross Face and Dog Head supplied in the following weights:

1½, 2½, 3, 3½, 4, 4½, 5, 6, and 7 lbs.

SAW MAKERS' ANVILS

Steel face supplied in the following weights:

70, 100, 150, 190, 250, 375, 450 lbs.

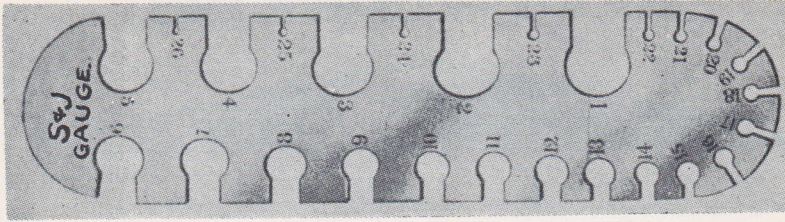


Anvil

"The Saw Without a Flaw"

Spear & Jackson

STANDARD SAW GAUGES



Gauge (Birmingham)	Fraction Inch	Thousandths	Millimeters
	1	1.000	25.40
	7/8	.875	22.225
	3/4	.750	19.05
	5/8	.625	15.875
	1/2	.500	12.70
	15/32	.468	11.905
0000	29/64	.454	11.53
000	27/64 Full	.425	10.79
00	3/8 Full	.380	9.65
0	11/32 Scant	.340	8.64
1	5/16 Scant	.300	7.62
2	9/32	.284	7.21
3	1/4 Full	.259	6.57
4	15/64	.238	6.04
5	7/32	.220	5.59
6	13/64	.203	5.18
7	3/16 Scant	.180	4.57
8	5/32 Full	.165	4.19
9	5/32 Scant	.148	3.76
10	1/8 Full	.134	3.40
11	1/8 Scant	.120	3.05
12	7/64	.109	2.77
13	3/32	.095	2.41
14	5/64 Full	.083	2.10
15	5/64 Scant	.072	1.82
16	1/16 Full	.065	1.65
17	1/16 Scant	.058	1.47
18	3/64	.049	1.24
19		.042	1.06
20		.035	.89
21	1/32	.032	.81
22		.028	.71
23		.025	.64
24		.022	.56
25		.020	.51
26		.018	.46
27	1/64	.016	.41
28		.014	.36
29		.013	.33
30		.012	.30

"The Saw Without a Flaw"

Spear & Jackson

CIRCULAR SAW SPEEDS

The large percentage of circular saws are operated at a rim speed of 9,000 to 10,000 feet per minute. However, we can tension saws to run at any desired speed. In table below, RPM of arbour is given for rim speeds of 8,000 to 14,000 feet.

Diameter of Saw in inches	Rim Speed — Feet per Minute				
	8,000	9,000	10,000	12,000	14,000
4	7,639	8,594	9,549	11,459	13,369
5	6,111	6,875	7,639	9,167	10,695
6	5,092	5,729	6,366	7,639	8,912
7	4,365	4,911	5,457	6,548	7,639
8	3,819	4,297	4,774	5,729	6,684
9	3,395	3,819	4,244	5,093	5,941
10	3,055	3,437	3,819	4,583	5,347
11	2,777	3,125	3,472	4,167	4,861
12	2,546	2,864	3,188	3,819	4,456
14	2,182	2,455	2,728	3,274	3,819
16	1,909	2,148	2,387	2,864	3,342
18	1,697	1,909	2,122	2,546	2,970
20	1,527	1,718	1,910	2,292	2,674
22	1,388	1,562	1,736	2,083	2,430
24	1,273	1,432	1,592	1,910	2,228
26	1,175	1,322	1,469	1,763	2,056
28	1,091	1,227	1,364	1,637	1,910
30	1,018	1,146	1,273	1,528	1,782
32	954	1,074	1,198	1,432	1,671
34	898	1,011	1,123	1,348	1,572
36	848	954	1,061	1,273	1,485
38	804	904	1,005	1,206	1,407
40	763	859	955	1,146	1,337
42	728	818	910	1,091	1,273
44	694	781	868	1,041	1,215
46	664	747	830	996	1,162
48	636	716	796	955	1,114
50	611	687	764	916	1,069
52	587	661	734	881	1,028
54	566	637	707	849	990
56	546	614	682	818	955
58	526	593	658	790	922
60	509	573	636	764	891
62	493	554	616	740	862
64	477	537	597	716	836
66	462	521	579	694	810
68	449	505	562	674	786
70	436	491	546	655	764
72	424	477	530	636	742
74	413	464	516	619	722
76	402	452	502	603	704
78	392	440	490	587	685
80	382	429	477	573	668
82	373	419	465	559	652
84	364	409	455	546	636
96	318	358	398	477	557
108	283	318	354	424	495

"The Saw Without a Flaw"

NOTES

THESE NOTES ARE A SUMMARY OF THE RESULTS OF THE RESEARCH WORK DONE BY THE AUTHOR DURING THE PAST FEW YEARS. THEY ARE NOT INTENDED TO BE A COMPLETE TREATISE ON THE SUBJECT, BUT RATHER A GUIDE TO THE READER'S INTEREST IN THE SUBJECT.

DATE	TIME	PLACE	REMARKS	REMARKS	REMARKS
1911	1912	1913	1914	1915	1916
1917	1918	1919	1920	1921	1922
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2007	2008	2009	2010	2011	2012
2013	2014	2015	2016	2017	2018
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3165	3166	3167	3168	3169	3170

NOTES

NOTES

Spear & Jackson

P R O D U C T S . . .

- WIDE BAND SAWS
- GANG SAWS
- DRAG SAWS
- SOLID TOOTH SAWS
- INSERTED POINT SAWS
- SHINGLE SAWS
- BITS
- SHANKS
- SAW REPAIRS

"The Saw Without a Flaw"